

Date: Wednesday, 04/07/2007 1:29:48 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOW RING
Job Number	: 33287		
Estimate Number	: 10396		
P.O. Number	: <i>N/A</i>	Part Number	: D2968041
This Issue	: 04/07/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2968
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: 33099	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 25/07/2007
Checked & Approved By	: _____	Qty:	20 Um: Each
Comment	: Est:C 03.04.14 Reformat; Incorporated D2968-1/5 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D29681	Stem
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Stem *130302*

FC 07 07 05 (20)

2.0	D29685	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Ring *13025030 x10 1302750 x11*

FC 07/07/05 (20)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D2968-1 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-041
 Batch: *1303794*

FC 07/07/05 (20)

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

130707/05 (20)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

1307/07/05 (20) ch/c

6.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting PURCHASING
 Issue P/O: *4114*

Description: D2968-041 to heat treat to ultimate tensile strength
 125ksi as per Dwg D2968

1307/07/06 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/07/2007 1:29:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 33287

Part Number: D2968041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Conformity sheet required

Issue P/O:

4115

C207/07/00

(20)

Cad Plate per QQ-P-416F Class I Type II

Conformity sheet required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/1/31 SP

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT CAD PLATE

En 02/08/01 (V20)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

M105068

(20X)

M-L 07/08/03

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/08/03 (20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/08/03 (20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/03 (20)

Job Completion



07-08-03

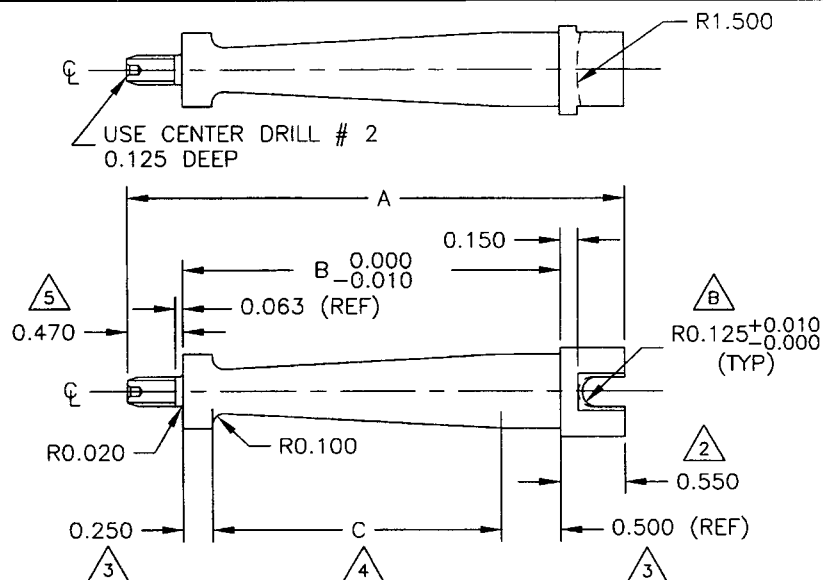
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

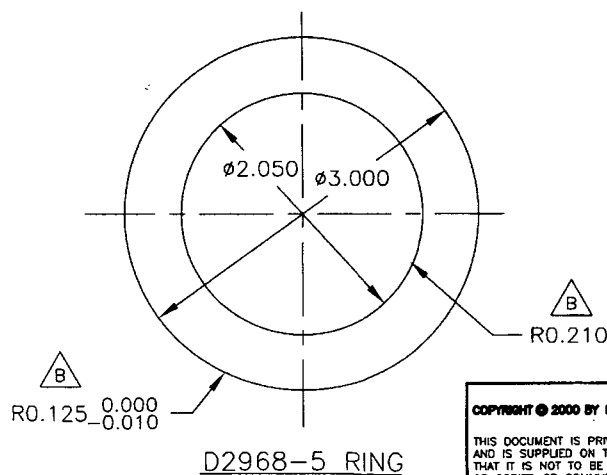
D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

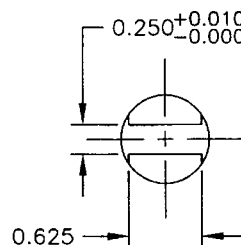
- 1) MATERIAL: AISI 4130N ROUND BAR PER MIL-S-6758 OR AMS 6348/6370/6528 (REF DART SPEC M4130N-RX.XXX)
- 2) $\phi 0.750$ O.D.
- 3) $\phi 0.625$ O.D.
- 4) MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D. TO $\phi 0.625$ O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

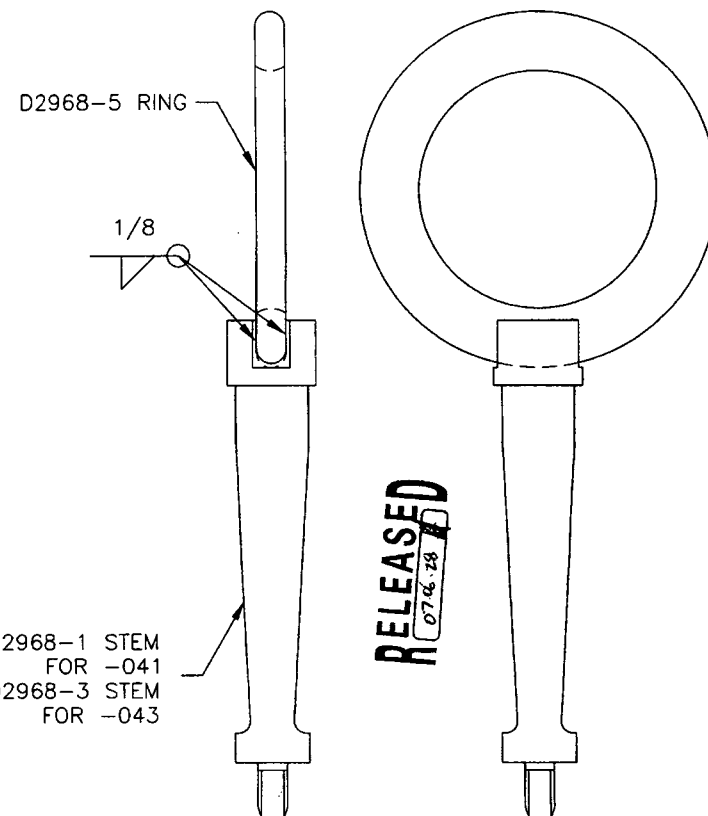
- 9) MATERIAL: AISI 4130N TUBING PER MIL-T-6736 OR AMS 6360/6361/6362/6371/6373/6374 (REF DART SPEC M4130NT3000W500)
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING



USE D2968-1 STEM FOR -041
USE D2968-3 STEM FOR -043



D2968-041 AND D2968-043 TOW RING:

- 12) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 13) HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
- 14) FINISH: CAD PLATE ENTIRE ASSEMBLY PER QQ-P-416F CLASS I TYPE II POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)

C	07.04.17	2.050 WAS 2.000, UPDATE NOTES
B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	<i>[Signature]</i>	DRAWN BY <i>[Signature]</i>
CHECKED	<i>[Signature]</i>	APPROVED <i>[Signature]</i>
DATE	07.04.17	TITLE TOW RING
DART	DART AEROSPACE LTD. WARRICKSURY, OXFORD, ENGLAND	
DRAWING NO.	D2968	REV. C
SHEET 1 OF 1	SCALE 1:1	

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VAC AERO
INTERNATIONAL INC.

PACKING SLIP

OAK 89022-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION
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CANADA H4S 1C5
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GST No.: R105468102

07/24/2007

MM/DD/YYYY

PAGE: 1

1DAR01

BILL TO: IART AEROSPACE LTD.
1270 ABERDEEN ST.
PAWESBURY, ON

SHIP TO: MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT Q.C.

16A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
07/23/2007	PUROLATOR 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
0004114		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D2968-041	B33287 TOW RING	EA	21	21	0
		Process Specifications: Procedure: 4047 HEAT TREATED TO 125 KSI MIN. 100% HARDNESS TESTED PER ASTM E-18, HRC 26-32 MATERIAL: 4130				
02	MC	MINIMUM CHARGE		1	1	0

CAD. Yellow

1 BOX

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT



HEAT



VAC AERO
INTERNATIONAL INC.

RELEASE NOT

GST No. : R105468102

OAK 89022-1



HEAD OFFICE
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07/23/2007

MM / DD / YYYY

PAGE : 1

BILL TO:

1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO : MANCO DOMPLEX
4660 HICKMORE
ST. LAURENT Q.C.

K6A 1K7

H4T 1K2

DATE SHIPPED	SHIP VIA	F.O.B.
07/23/2007	PUROLATOR 7684382	ORIGIN
CUSTOMER P/O No.	JOB No.	TERM
00004114		COD

PAR No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
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D2968-041 B33287 TOW RING EA 21 21

Process Specifications: Procedure: 4047
HEAT TREATED TO 125 KSI MIN.
100% HARDNESS TESTED PER ASTM E118, HRC 26-32
MATERIAL: 4130

100% HARDNESS TESTED

21 PCS.

29/30 REC

JK



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Douglas Robinson
Authorized Q.C. Inspector

